

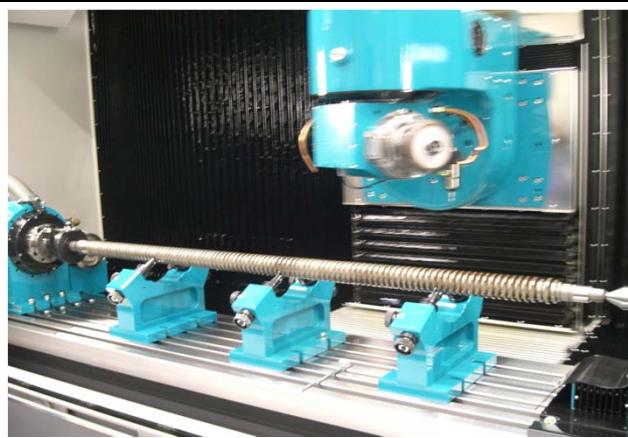
## Round broach WS 26624

A14-020

The production process of this example tool contains full depth grinding of spline with the depth of 3.04mm and removal rate of 0.1mm per pass. Dressing in between cycles and certain finishing cycles are also necessary here.

The profile is made with profiled wheel which is calculated and dressed directly on the machine. The tool is clamped between centers, supported by steady rests and is driven by dog and driver.

This calculation includes also grinding of O.D. and resharpening time for serrations. Division of teeth can be entered directly in Quinto software or probed by 3D probe on the machine.



Example broach of same size on Corvus BBA

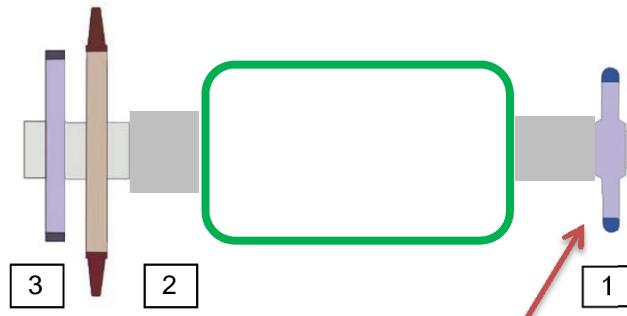
### 1. Cycletime for Production

Workpiece: WS 26624 Length: 850mm; Diameter: 70mm; Nr. of teeth: 112 Material HSS				
Operations	Probe	Flute 1	O.D.	Profiling
Feed [mm/Min]	3000	5	5	5000
Power [kW]		3	2	3
Cutting feed [m/s]		25	28	30
Used wheels				
Grinding time [min]	6	95	110	180
Total cycle time	6h 31min			

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1	14F1 Ø80 B91
2	Profiled 53A80 Ø250
3	1V1 70° B91



### 3. Machine and Software Requirements

Machines: CNC grinders : Corvus BBA / C360  
 Control: Fanuc 160i / 310i  
 Accessories: Dog and driver, Tailstock, Support, Magnetic plate  
 Responsible engineer: SIW, 02.2016

Coolant: Synthetic Oil, pressure 6 bar  
 Software: Quinto

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 J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland  
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